

**Work Order ID 62950**

Thursday, October 14, 2010 12:34:58 PM

Page 1

Item ID: D2332-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Lid Prop Assembly 6.69" long

Start Date: 10/14/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2332

Rev C1

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

⇒ m-d 10/10/27

110

0.00



Brake NC

Memo

0.00

Brake NC

Punch and form D2332-11 to length as per dwg D2332 using DT8012  
( need 2 per ass'y)

⇒ m-d 10/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




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Required Date:	10/22/2010	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  Small Fab		0.00							
Small Fab	Memo	0.00							
	1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y)								
	2- Ensure no foreign objects inside tube								
	3- Deburr								
130  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
140  Large Fab		0.00							
Large Fab	Memo	0.00							
	Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y) *****ensure nothing is inside of tube before welding*****								
	S.S Rod batch: <u>M114 509</u>								

⇒ m.k. 10/10/27

D2332-7 - 8/10/10/28 (410)  
D2332-5 - 8/10/10/28 (410)  
D2332-13 - 8/10/10/28 (410)  
D2332-11 - 8/10/10/28 (410)

(10X)

(710)

EL 10-72-1 (410)

W/O:		WORK ORDER CHANGES					
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Required Date: 10/22/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

CPL 10.12.02

QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

8/10/12/02

QC

Memo

0.00

Quality Control

170

0.00

Small Fab

Memo

0.00

Small Fab

1- Tumble

2- Assemble as per dwg D2332



B 10-12-7

(10)

ES 10/12/07 (10)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

190

Identify as per dwg &amp; Stock Location: S12

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

(H0)

10/12/17 SQ (100)

10/12/08 JF  
mf  
10-12-08

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# Picklist Print

Thursday, October 14, 2010 12:35:02 PM

Page 1

Work Order ID: 62950

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long



Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF  
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304R.250		Purchased	No			100	f	36.5579	0.1	1.052632			
304 SS Round bar .250													

Location	Loc Qty	Loc Code
MAT	24	
114482	24	
MAT028	12.557868	
107387	12.557868	

*M-L 10/10/26*  
1.052632

M304TR1.000W.049		Purchased	No			100	f	28.0416	0.43	4.526316			
304 RD Tube 1.00 x .049W													

Location	Loc Qty	Loc Code
MAT018	28.041584	
108756	10.08	
111457	17.961584	

*M-L 10/10/26*  
4.526316

M304TR0.500W.035		Purchased	No			110	f	94.7399	1.25	13.15789			
304 RD Tube .500 x .035W													

Location	Loc Qty	Loc Code
MAT	94.739837	
2x 114482	0.002677	
115180	0.93405	
115535	13.80311	
4x 115593	80	
MAT014	0.00002	
2x 114356	0.00002	

*M-L 10/10/26*  
13.15789  
~~1.325~~  
~~5-28346~~  
2.63158  
~~1-325~~  
~~2.63158~~

*4x 112800*

*\**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 10.00

Required Qty: 10.00

AN4-4A Purchased No

170 Each

186.0000

1 10



Bolt



*Ep 10/12/07*

10

Location

Loc Qty

Loc Code

ST356

183

114615

183

ST361

3

108138

2

111295

1

AN960JD416L NAS1149D0416J Purchased No

170 Each

223.0000

3 30



Washer



*Ep 10/12/07*

*LD M115107*  
*(304)*

Location

Loc Qty

Loc Code

ST346

223

106785

2

110153

221

MS21042L4 Purchased No

170 Each

3,882.000

1 10



Nut



*Ep 10/12/07*

Location

Loc Qty

Loc Code

ST300

3882

113422

68

114523

8

114718

16

114784

32

115108

758

115589

1900

115621

1100

10

W/O:		WORK ORDER CHANGES					
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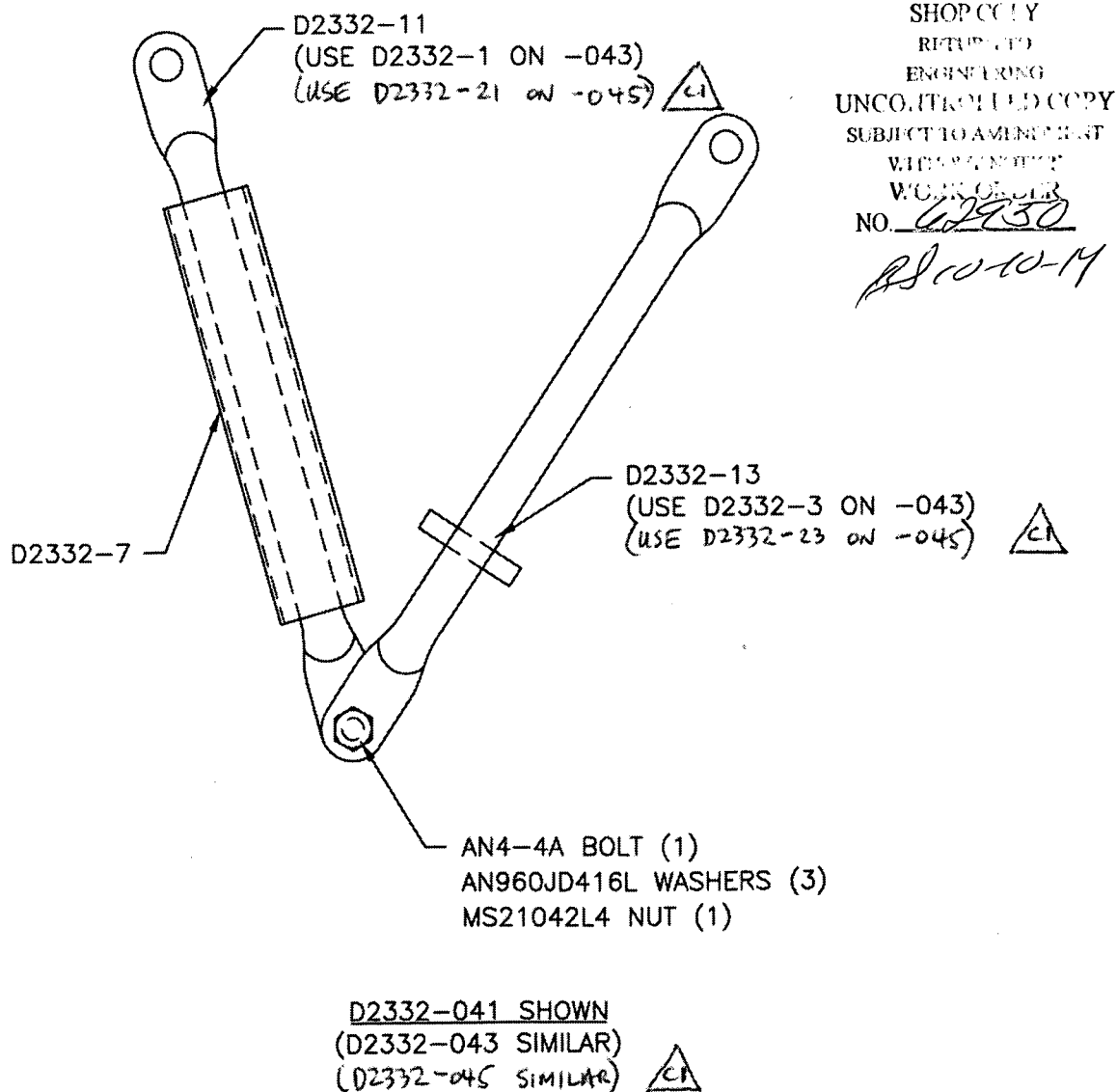
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**NOTE:** Date & initial all entries



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE	03.07.03			TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE			
B	97.09.30	CHANGE 416 WASHERS TO 416L			
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)			
C1	<i>[Signature]</i> 03.08.06	ADD -045 PROP (7.25" LONG)			

RELEASED  
03.07.04 *[Signature]*



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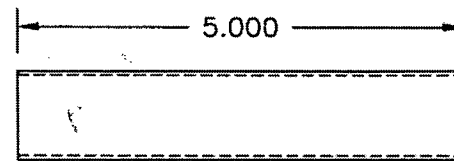
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**DART**

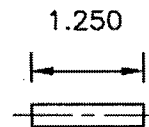


DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 03.07.03	DRAWING NO. D2332	REV. C
	TITLE LID PROP ASSEMBLY	SHEET 2 OF 2
		SCALE 1:2
C	03.07.03	MAKE - 041 PROP 6.69" LONG (END)
C1	03.08.06	MAKE - 043 PROP 8.00" LONG (INT)
		ADD - 045 PROP 7.25" LONG

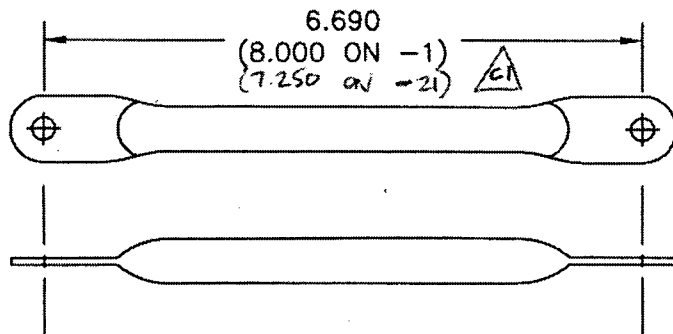


D2332-7 LOCKING COLLAR

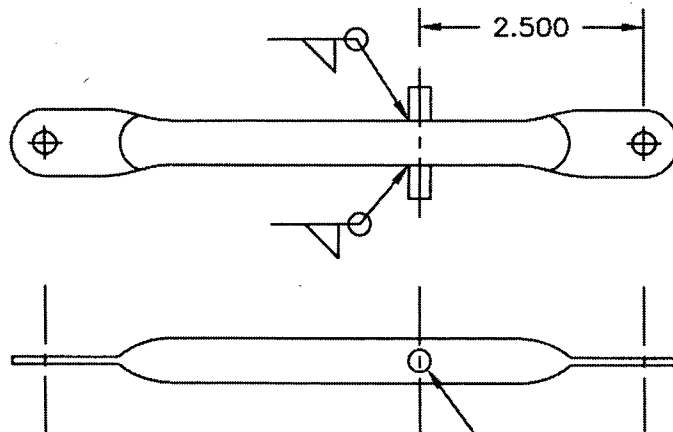
*wlo 62930*



D2332-5 STOP PIN



D2332-11 PROP  
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13  
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)  
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)



NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035  
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250  
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED  
03.07.04

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